



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3167-1

Job Sheet 186369



Part No: D3167-1

Job Qty: 10 ea

Part Name: Bearpaw



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/14/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A1

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
120	Waterjet - Flow - 1	10 pcs	11/30/18	11/30/18	0.00	3.39	Waterjet - Flow	BAS 11/23
130	CNC Vertical Machining	10 pcs	11/30/18	11/30/18	0.66	16.39	HAAS1-3	52 18/12/23
140	QC	10 pcs	11/30/18	11/30/18	0.00	0.00	QC2 Machining-1	9-89 18/12/23
150	QC	10 pcs	11/30/18	11/30/18	0.00	0.00	QC8 Machining-1	9-89 18/12/23
151	Packaging	10 pcs	11/30/18	11/30/18	0.00	0.00	Packaging3	DEC 27 2018
190	QC21-SA	10 Ea	11/30/18	11/30/18	0.00	0.00	QC21	DEC 27 2018 70 9-89

Part Op 120 - Cut Blank as per File D3167-1_BLANK
Descriptions: 130 - Note: (2) Bearpaw for (1) Kit 2-Machine as per Folio FA285 and Dwg D3167

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	36 sf (3.6 ea)	120-Waterjet - Flow - 1	5045598

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Waterjet - Flow - 1	MUHMWB10	36	535	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	0.060inches + 0.030 - 0.010	0.090 0.050	06	
2	Bearpaw	45.000Degrees ± 0.500	45.500 44.500	45°	
3	Bearpaw	5.800inches ± 0.030	5.830 5.770	5.800	
4	Bearpaw	0.250inches ± 0.030	0.280 0.220	0.250	
5	Bearpaw	45.000Degrees ± 0.500	45.500 44.500	45°	
6	Bearpaw	0.250inches ± 0.030	0.280 0.220	0.250	Radius
7	Bearpaw	0.200inches ± 0.030	0.230	0.200	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube</td> <td style="width: 15%;">Cross tube</td> <td style="width: 15%;">Water Jet</td> <td style="width: 15%;">Engineering</td> </tr> <tr> <td>Machining</td> <td>Small Fab</td> <td>Prod. Eng. Coord.</td> <td>Quality</td> </tr> <tr> <td>Thermoforming</td> <td>Finishing</td> <td>Rec/Store/Packaging</td> <td>Other</td> </tr> <tr> <td>Large Fab</td> <td>Composite</td> <td>Supplier</td> <td></td> </tr> </table>						Skid-tube	Cross tube	Water Jet	Engineering	Machining	Small Fab	Prod. Eng. Coord.	Quality	Thermoforming	Finishing	Rec/Store/Packaging	Other	Large Fab	Composite	Supplier	
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			0.170	
8	Bearpaw	0.250inches $\pm$ 0.010	0.260 0.240	0.250
9	Bearpaw	0.625inches $\pm$ 0.030	0.655 0.595	0.625
10	Bearpaw	0.375inches $\pm$ 0.010	0.385 0.365	0.375
11	Bearpaw	0.950inches + 0.030 - 0.010	0.980 0.940	0.950
12	Bearpaw	3.210inches $\pm$ 0.030	3.240 3.180	3.210
13	Bearpaw	19.000inches $\pm$ 0.030	19.030 18.970	19.000
14	Bearpaw	0.260inches $\pm$ 0.005	0.265 0.255	Diameter ϕ . 260
15	Bearpaw	0.930inches $\pm$ 0.030	0.960 0.900	Diameter ϕ . 930
16	Bearpaw	0.300inches + 0.030 - 0.000	0.330 0.300	0.315
17	Bearpaw	0.375inches $\pm$ 0.030	0.405 0.345	0.375
18	Bearpaw	7.230inches $\pm$ 0.030	7.260 7.200	7.230
19	Bearpaw	4.540inches $\pm$ 0.010	4.550 4.530	4.540
20	Bearpaw	2.000inches $\pm$ 0.030	2.030 1.970	2.000
21	Bearpaw	12.000inches $\pm$ 0.010	12.010 11.990	12.000
22	Bearpaw	6.000inches $\pm$ 0.010	6.010 5.990	6.000
23	Bearpaw	23.750inches $\pm$ 0.030	23.780 23.720	23.750

Plex 11/14/18 3:01 PM Dart.lajeunesse.marie

DART
AEROSPACE

Container No: S130819

Part: D3167-1
Job No: 186369
Serial No/Batch: S130819

Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 11/23/18

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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